

Date: Thursday, 11/15/2007 1:20:34 PM  
 User: Kim Johnston

## Process Sheet

49

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: R44 BEARPAW
Job Number	: 35754A		
Estimate Number	: 10100		
P.O. Number	: N/A	Part Number	: D30751
This Issue	: 11/15/2007 S.O. No. : N/A	Drawing Number	: D3075 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 35348A	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 12/5/2007
Checked & Approved By	: <i>[Signature]</i> 07.11.16	Qty:	20 Um: Each
Comment	Est Rev: C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM Est Rev: D Added C'Bores as per Rev B 07-03-28 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 1.8949 sf(s)/Unit Total : 37.8980 sf(s)

Pick:

blank: 10.50" x 13.00" x 1.00" thick (+0.030/-0.000) per DSK086-12

Material: Black UHMW 1"(MUHMWB10)

Batch: *1101254 DSP 07/11/20*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA185 and Dwg D3076 Identify as D3075-1

3-Deburr

*SF 07/11/22* (12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SF 07/11/22* (12)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SJ 07.11.23* (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 07/11/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/15/2007 1:20:35 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 BEARPAW

Job Number: 35754A

Part Number: D30751

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PPP

35348

10/11/28

(12)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

10/11/28

Job Completion



10/11/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 35754A
<b>Description:</b> R44 Bearpaw		<b>Part Number:</b> D3075-1
<b>Inspection Dwg:</b> D3075	<b>Rev:</b> A2 <i>07/11/10</i>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

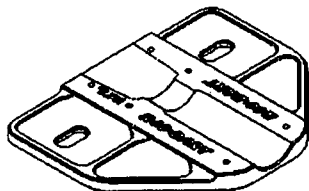
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	0.07 x 45°	✓		
B	0.63	+/-0.030	0.615	✓		
C	0.250	+/-0.010	0.245	✓		
D	0.950	+0.030/-0.010	0.955	✓		
E	5.50	+/-0.030	5.503	✓		
F	0.25 x 45°	+/-0.030	0.25 x 45°	✓		
G	0.900	+/-0.010	0.890	✓		
H	0.375	+/-0.010	0.383	✓		
I	1.30	+/-0.030	1.28	✓		
J	5.70	+/-0.030	5.710	✓		
K	0.37	+/-0.030	0.382	✓		
L	3.600	+/-0.010	3.605	✓		
M	0.260	+0.005/-0.000	0.260	✓		
N	0.93	+/-0.030	0.955	✓		
O	0.30	+0.030/-0.000	0.307	✓		
P	1.08	+/-0.030	1.053	✓		
Q	5.870	+/-0.010	5.8785	✓		
R	10.14	+/-0.030	10.151	✓		

<b>Measured by:</b> DSP/SF	<b>Audited by:</b> J.L	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/11/21	<b>Date:</b> 07/11/21	<b>Date:</b>	N/A

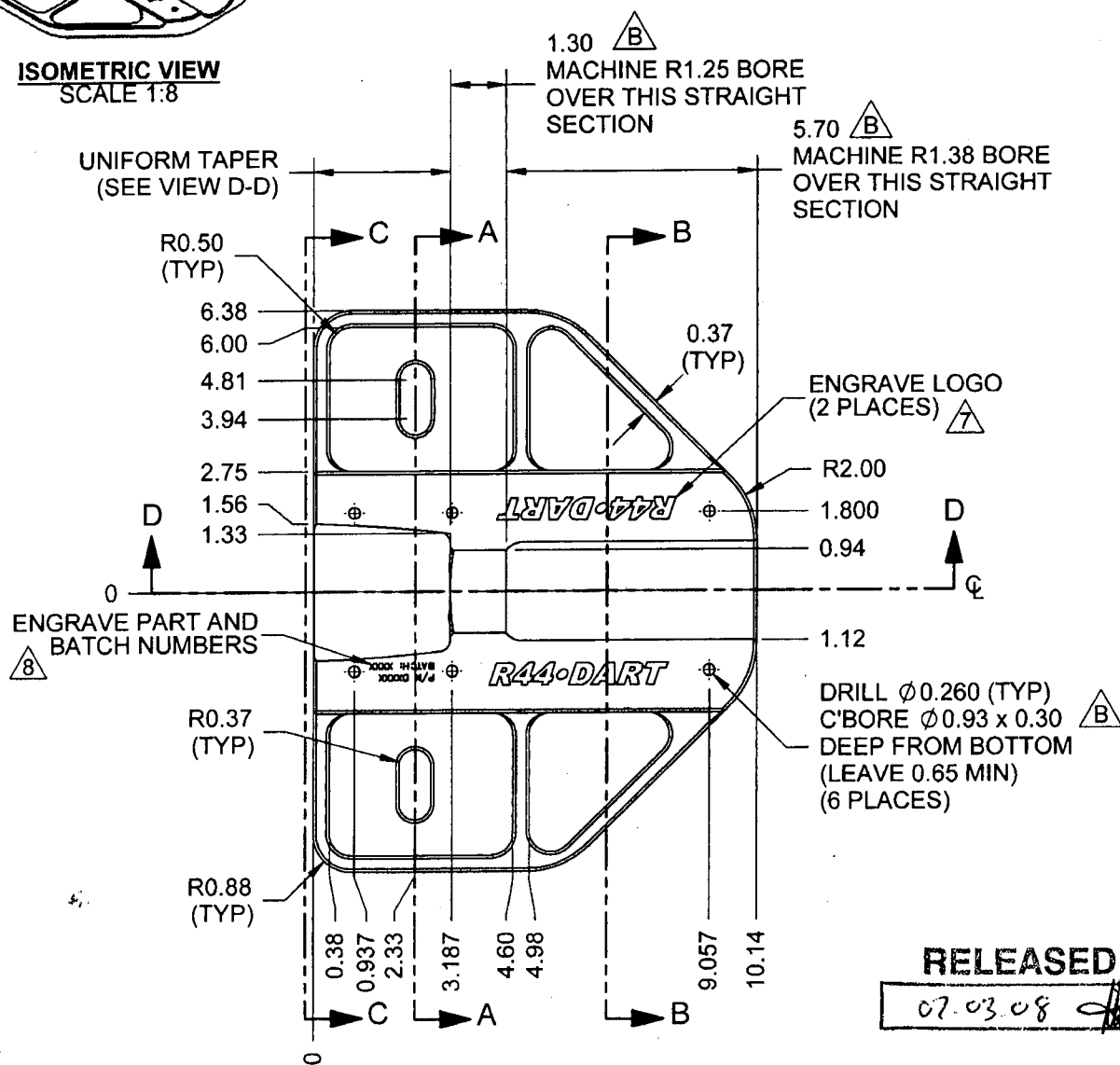
Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue P/O D044-662-011	KJ/RF	✓



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3075	REV. B SHEET 1 OF 2
DATE 07.02.27		TITLE R44 BEARPAW	SCALE 1:4
REV	DATE	DESCRIPTION	
A	02.01.04	NEW ISSUE	
B	07.02.27	1.30 WAS 1.60; 5.70 WAS 5.84; $\phi 0.93$ WAS $\phi 0.75$ ; ADD QTY(2) HOLES AT (0.937, $\pm 1.800$ )	



ISOMETRIC VIEW  
SCALE 1:8



D3075-1 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

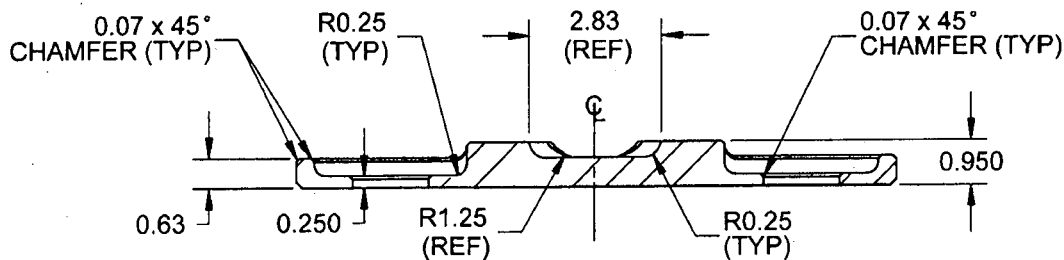
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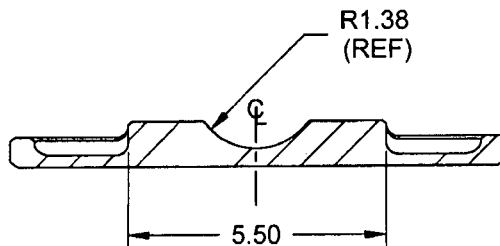
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WORK ORDER  
35754A



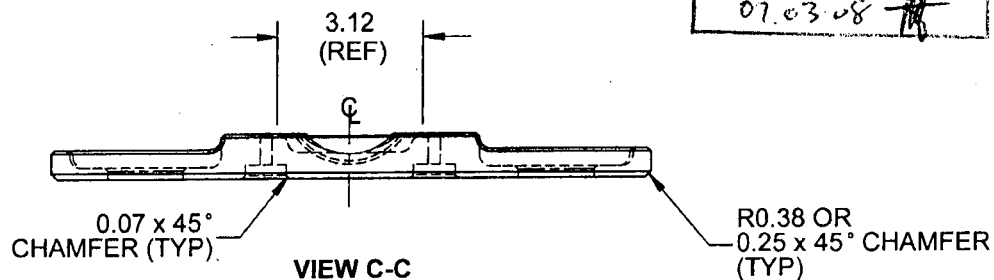
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3075	REV. B SHEET 2 OF 2
DATE 07.02.27	TITLE R44 BEARPAW		SCALE 1:4



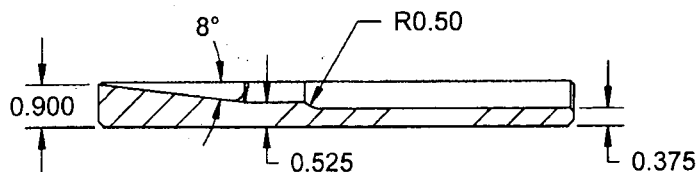
**SECTION A-A**



**SECTION B-B**



**VIEW C-C**



**SECTION D-D**

**RELEASED**

07.03.08

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